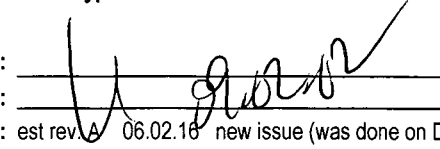


Date: Wednesday, 18/02/2009 2:57:52 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SIDE DOOR  
 Job Number : 45407  
 Estimate Number : 12296  
 P.O. Number :  
 This Issue : 18/02/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 02/02/2009 Type : PURCHASED PARTS  
 Previous Run : 45406  
 Part Number : D350589042  
 Drawing Number : D2991 REV.C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 20/02/2009 Qty: 1 Um: Each  
 Written By :   
 Checked & Approved By :  
 Comment : est rev A 06.02.10 new issue (was done on D350-589-041)  
 EC  
 Est Rev: B 08-02-20 ECN1096 DD verified by: EC  
 est rev C 08.06.26 revised pick list per QC comments  
 (w/o25886) EC verified : DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D350-589-042

CHG008/4

2.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8112

C209/02/03 ①

Description: D2991-2 side door

Supplier: Delastek

batch:

Ship to delastek: Qty 2 D2992-1

Doubler

B38743

C209/02/03 ②

Ensure batch # on Label D3721-2 match W/O # for D350-589-042

Certificate of Conformity and process sheet from Delastek is required

B46789 C209/04/15 ②

3.0 D29921 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

C209/02/03 ②

4.0 D29912 Side Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Side Door

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/05/29		Chg 004 - Larger Hinge Plates	<i>[Signature]</i>	09/09/29		<i>[Signature]</i> 09/09/29	<i>[Signature]</i> 05/08/29

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 18/02/2009 2:57:52 PM  
User: Linda Laëlle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45407

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

09/05/28 ①

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

09.05.28 1

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description
1	D2464-1700	Foam seal

Batch

B39669

090529 1

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3.0000~~ Each(s) 4

Pick:

Qty	Part number	Description
3	D2585	Latch clamp

Batch

45815.

DS19463

PTO →  
09/05/29 (X)

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3.0000~~ Each(s) 4

Pick:

Qty	Part number	Description
3	D2586	Door latch

Batch

45554

DS19463

09/05/29 (X)

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3.0000~~ Each(s) 4

Pick:


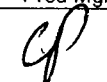
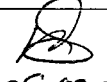
Qty	Part number	Description
3	D2621	latch plate

Batch

41175

DS19463

09/05/29 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090529	8.0	<del>1.0</del> quantity changed to accomodate DSI 9463		09.05.29	1	 09.05.29 DSI 042	 09.05.29	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45407

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	415557

88 09105/29 (K)

12.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3.0000~~ Each(s) 4 DS19463

Pick:

Qty	Part number	Description	Batch
3	AN960JD10	Washer	M111279

P10

88 09105/29 (K)

13.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : ~~6.0000~~ Each(s) 7 DS19463

Pick:

Qty	Part number	Description	Batch
6	MS21042L3	Nut	M111279

M110844

88 09105/29 (K)

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3.0000~~ Each(s) 4 DS19463

Pick:

Qty	Part number	Description	Batch
3	MS27039-1-15	Screw	M110915

88 09105/29 (K)

15.0

D37212

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: 45493

88 09105/29 (K)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1









Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

090529

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090529	16	Core removed and two layers of 902 cloth to accommodate latch placement of DSI 9463 902 cloth FG78150550 M111166 9330 EA Hysol M110970		090529	1	 09.05.29 051042	 050829	
090529	13	Change washer to 10L M109632 Permanent Change		090529	1	 090529	 090529	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.05.29	16	Small cut was created When opening hole for latch	<i>[Signature]</i> 090529	Repair cut by rounding <sup>and</sup> using Polyester Resin M110970 Mit Sibre M100859 Send it back up primer See attached email	<i>[Signature]</i> 090529	<i>[Signature]</i> 090529	<i>[Signature]</i> 090529	<i>[Signature]</i> 090529

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:57:52 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45407

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809.05.29 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick kit:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch:

46896

809.05.29 @

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch:

45585

809.05.29 @

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

14 D2237

Striker Plate

B46162

809.05.29 @

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

1 D2589

keys, key chain

B46840

809.05.29 @

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6 AN3-4A

Bolt

M163641 x3

M163915 x3

809.05.29 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 18/02/2009 2:57:52 PM  
User: Linda Lagelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45407

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~6.0000~~ Each(s) 8 ~~9~~ DSI 9463

Pick:

Qty Part number Description Batch  
MS20470AD4-5 Rivet M109031

25.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

M110844

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D

9/15/29

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-29

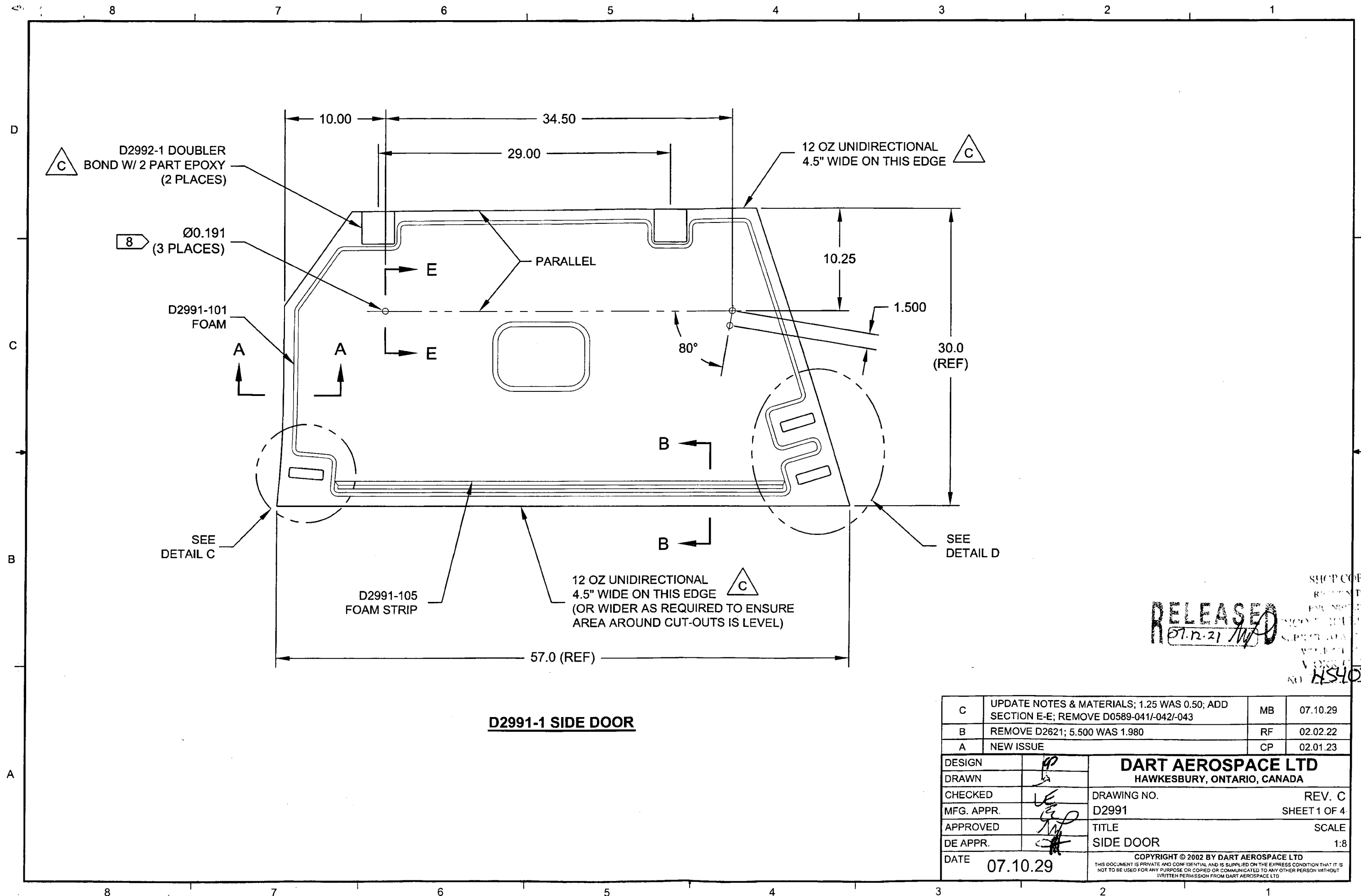
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

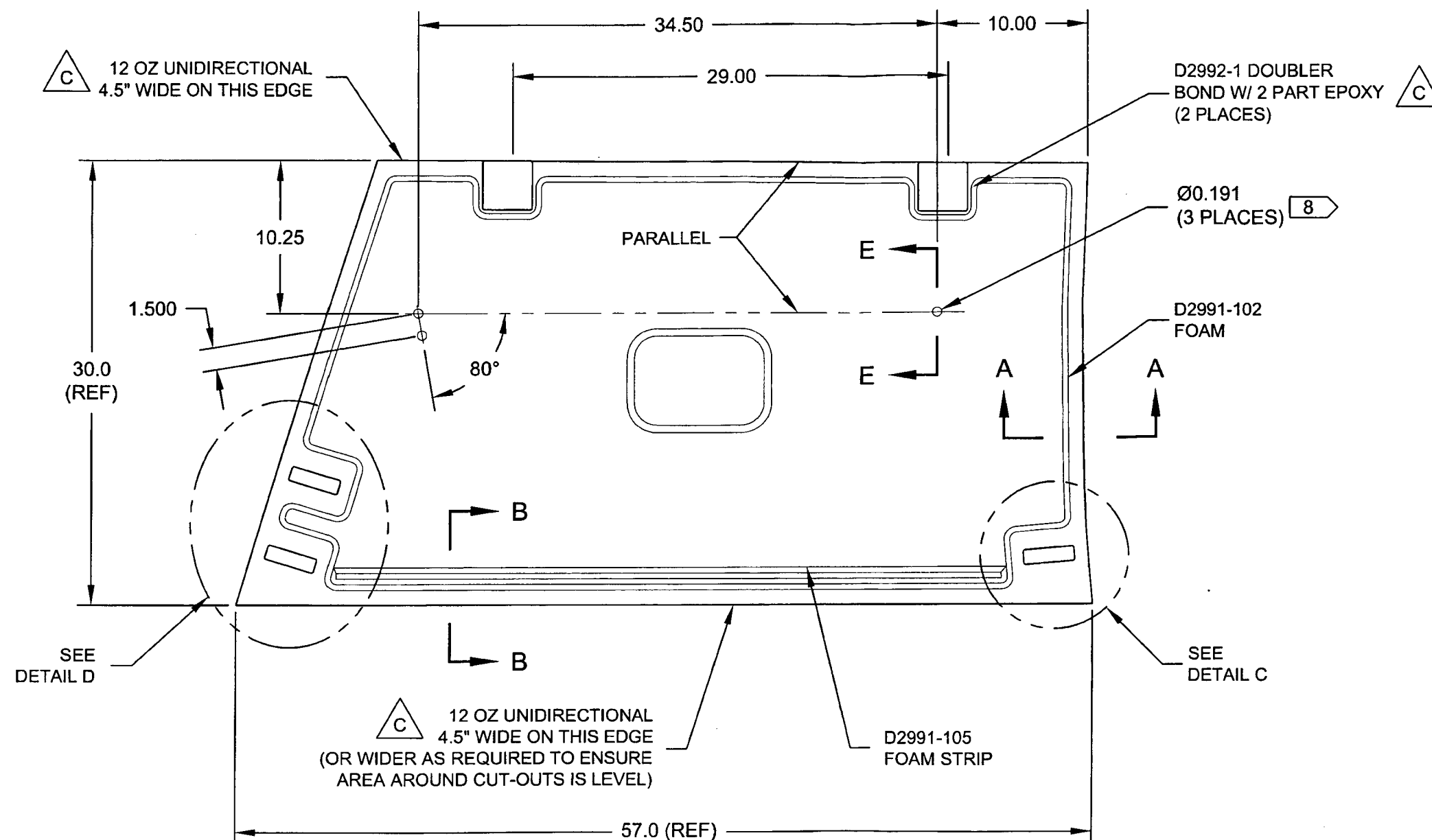


**D2991-1 SIDE DOOR**

SHOT COPY  
 RETURN TO  
 FOR REWORK  
 NO. 45407







**RELEASED**  
 07.12.21

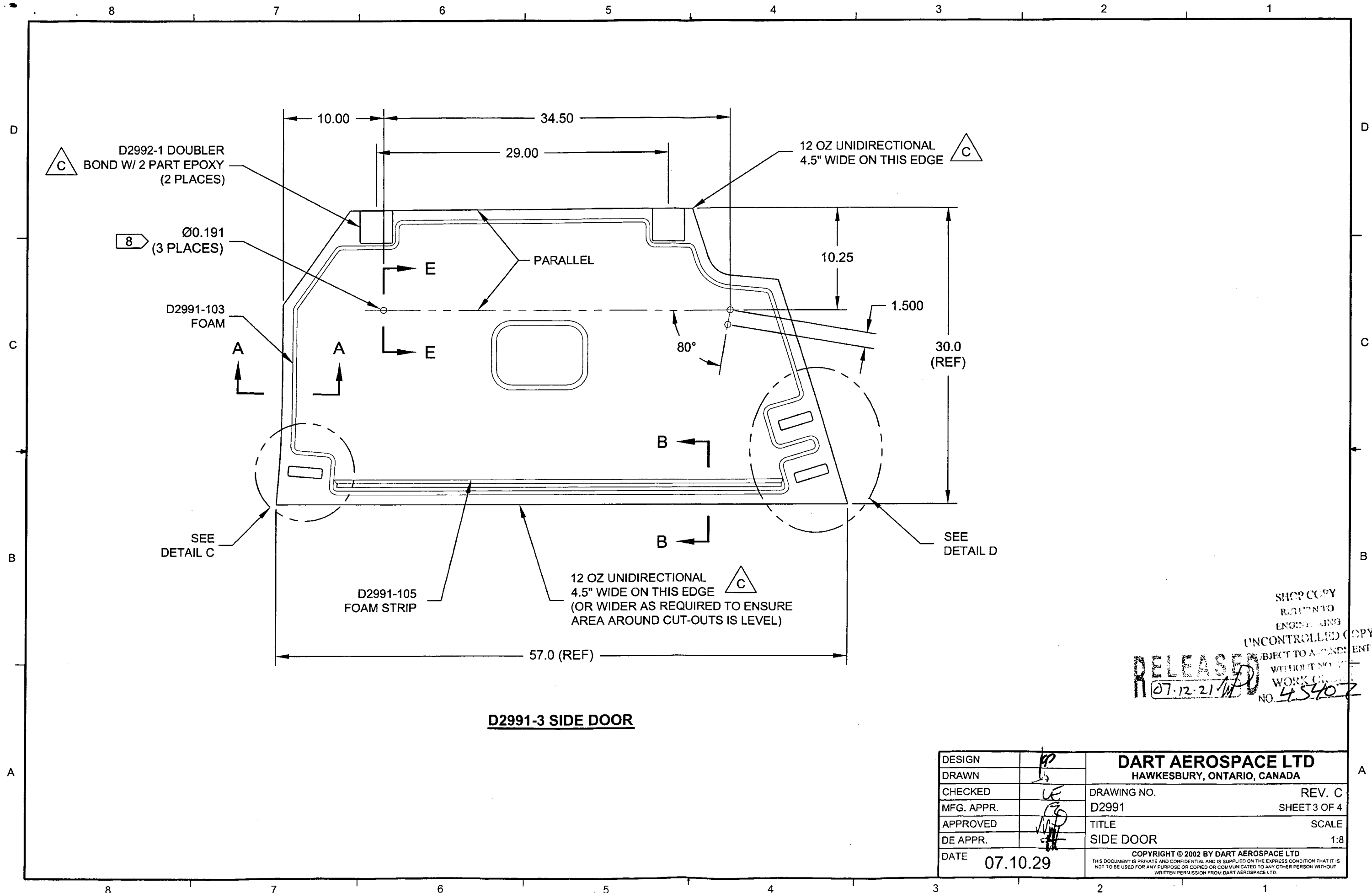
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2991	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D2991-2 SIDE DOOR**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 45407

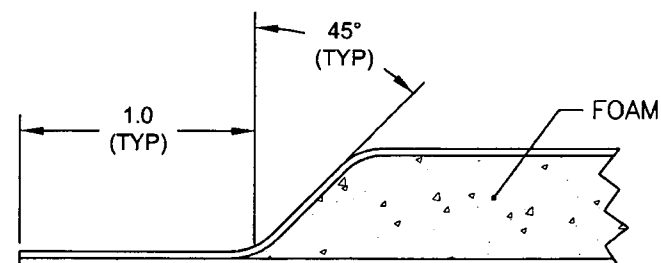
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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**D2991-3 SIDE DOOR**

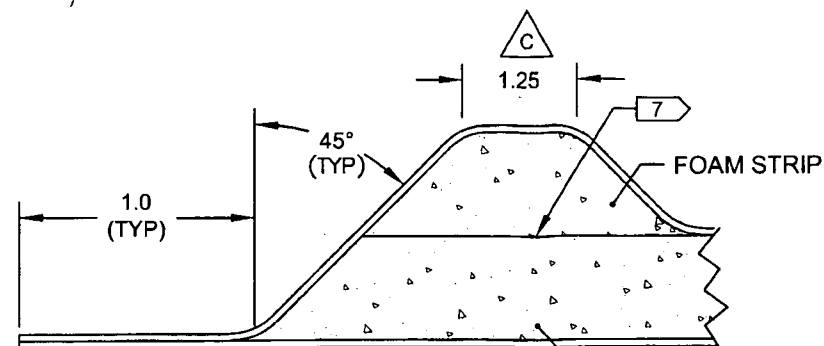
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO A CHANGE  
WITHOUT NOTICE  
WORK ORDER NO. 45407  
**RELEASED**  
07.12.21

DESIGN	10	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	13		
CHECKED	16	DRAWING NO.	REV. C
MFG. APPR.	17	D2991	SHEET 3 OF 4
APPROVED	18	TITLE	SCALE
DE APPR.	19	SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



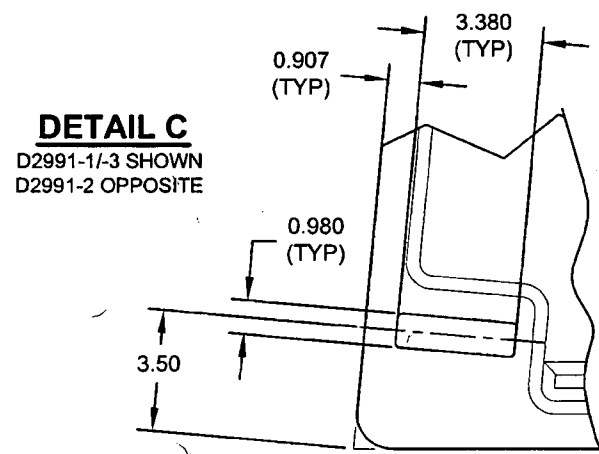
### SECTION A-A

NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



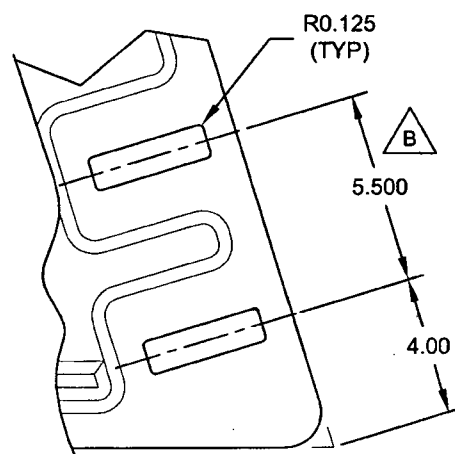
### SECTION B-B

ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



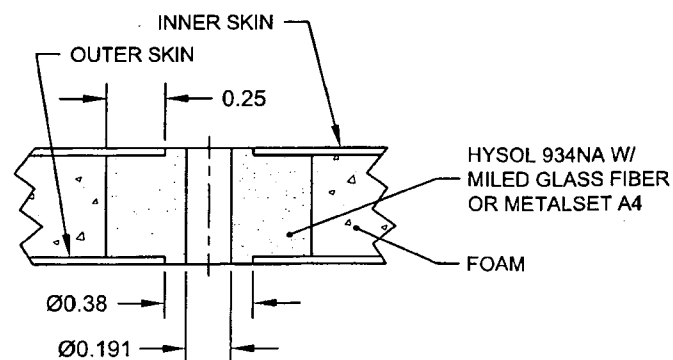
### DETAIL C

D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



### DETAIL D

D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



### SECTION E-E

TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE

### NOTES FOR D2991-1/-2/-3

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS:  
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- 13) WEIGHT: 9 lbs (TYP)

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	92	DRAWING NO.	REV. C
MFG. APPR.	92	D2991	SHEET 4 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	SIDE DOOR	1:
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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RELEASED  
07.12.21

NO. 43107



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13170
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/05/2009	03/02/2009	5973	Chantal Lavoie		PO00008112		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0050	Side Door N° D2991-1 B45404 Dwg.: D2991 Rév.: C annoté Job: 43779 U de M : Each			
1	0	1	DKC134-0051	Side Door N° D2991-2 B45407 Dwg.: D2991 Rév.: C annoté Job: <del>43779</del> 43781 U de M : Each			

It is hereby certified that all materials, process and finished items were  
controlled and tested in accordance with the requirements of the purchase  
order and applicable specifications. All such records are on file at our plant  
and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Jeudi, 2009-04-23 08:40:50  
Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART Dart Aerospace Ltd.  
Numéro Job : 43781  
Numéro Soumission : 2644  
Numéro B.A. :  
Cette fois : 2009-04-23 No. B.V. :  
Prsht Rev. : NC  
Prem. fois : - - Type :  
Job précédente : 43780  
Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Client: D2991-2

Nom Dessin : SIDE DOOR N° D2991-2  
Numéro Article : DKC134-0007 134-0007  
Numéro Dessin : D2991  
Projet Numéro : DKC134  
Révision dessin : ~~D~~ Canote  
Matériel : Composites  
Date Dûe : 2009-04-30 Qté: 1 UdM: UNITE

DELASTEK M-2  
DELASTEK S-1  
DELASTEK S-1

Process Sheet Rev.: 00 Création du premier.

Produit additionnel

Numéro Job: 

# Séq.: Machine ou Opération: Description :

1.0 AAC0582 Frekote 700NC N° 38425 X # Lot: 



Commentair Qty.: ~ 0.025 GALLON(s)/Unit Total: 0.025 GALLON(s)

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0095 selon le QSI-006 et selon IG 0009.

Date: 23-4-09 Sceau:  

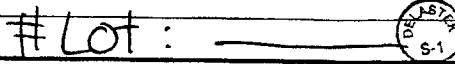
3.0 AAC0273 Gel Coat Blanc N° Gel 944W005 X

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s) # Lot: 1-7047-1

4.0 AAC0275 Catalyst N° DDM-9 X

Commentair Qty.: 0.0250 PINTE(s)/Unit Total: 0.0250 PINTE(s) # Lot: 1-22176-1

5.0 AAC0198 UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total: 0.014 GALLON(s) # Lot: 

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% de UN2055 styrene monomere ST

Date: 11-05-09 24-4-09 Sceau:  Temps Début: 9:00 Temps Fin: 9:15



Date: Jeudi, 2009-04-23 08:40:50  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43781

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	GEL COAT.	APPLICATION DE GEL COAT
-----	-----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du Gel coat sur le moule N° DKO-0095 selon IG 0019

11-5-09

Date: 11-5-09

Sceau:



8.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

9.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

10.0	AC0408	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

11.0	AC0752	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)

12.0	AAC0276	Fiberglass 9oz Type "S" N° FG778138-125Y
------	---------	--

x # Lot: 1-7017-1

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)

13.0	AAC0443	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

x # Lot: 1-21789-1

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

14.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz: pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

11-5-09

Date: 11-5-09

Sceau:



Date: Jeudi, 2009-04-23 08:40:50

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-2

Numéro Job: 43781

Numéro Article: DKC134-0067

Numéro Job:



# Séq.: Machine ou Opération: Description :

16.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020 X

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s)

# Lot: 1-24094-1



17.0 AAC0275 Catalyst N° DDM-9 X

Commentair Qty.: 0.0060 UNITE(s)/Unit Total: 0.0060 UNITE(s)

# Lot: 1-22176-1



18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

11-05-09

Date: 24-4-09 Heure Début: 1:30 Heure Fin: 1:35 Sceau:



19.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0095 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

11-5-09

Date: 24-4-09 Heure Début: 1:35 Heure Fin: 2:00 Sceau:



20.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

11-5-09

Date: 24-4-09 Sceau:



Curing début: 1:35 Curing Fin: 8:00

21.0 AAC0452 Polybond B46F X

Commentair Qty.: 0.143 KIT(s)/Unit Total: 0.143 KIT(s)

# Lot: 1-6724-1



22.0 DKC134-0063 Foam Core N° D2991-102( Porte D2991-2 ) X

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

# Lot: 43798



Date: Jeudi, 2009-04-23 08:40:50  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43781

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.: Machine ou Opération: Description :

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Assembler le Foam Core DKC134-0063 Selon IG 0033

Date: 15-5-09 1:40 Heure Début: 9:30 Heure Fin: 1:55 Sceau: 34 7



24.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Date: 15-5-09 1:40 Sceau: 34 7



Curing Début: 9:30 Curing Fin: 10:40

25.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)

26.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0040 UNITE(s)/Unit Total : 0.0040 UNITE(s)

27.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 15-5-09 10:20 10:25 Heure Début: 10:20 Heure Fin: 10:25 Sceau: 34 7



28.0 LAMINAGE LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 15-5-09 10:25 11:20 Heure Début: 10:25 Heure Fin: 11:20 Sceau: 34 7



Date: Jeudi, 2009-04-23 08:40:50

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-2

Numéro Job: 43781

Numéro Article: DKC134-0067

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

29.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date:

19-5-09

Heure Début:

11:20

Heure Fin:

11:30

Sceau:



Curing Début:

10:25

Curing Fin:

3:40

30.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date:

20-5-09

Sceau:



31.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

À l'aide du gabarit N° DKO-0119 trimmer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Perçer les " Latch " et les trous de peinture selon le dessin N° D2991.

Date:

21-5-09

Sceau:



32.0

AAC0433

Hysol 934NA part A&amp;B (quart kit)

Commentair Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)

X

# Lot: 1-22083-1



33.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total: 0.0002 GALLON(s)

X

# Lot: 1-6872-1



34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0119 Perçer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

Date: Jeudi, 2009-04-23 08:40:50  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 43781

Nom Dessin: SIDE DOOR N° D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seringue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 21-5-09 Sceau:



35.0

TRIMAGE

TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKO-0119 Repercer les 3 trous de 1/4" Dia.

Date: 22-5-09 Sceau:



*Araldite 2013 HQ 22/05/09*

36.0

AAC0433

Hysol 934NA part A&B (quart kit)

*# Lot: 1-24284-1*

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

37.0

AAC0697

N° D2992-1, Doubler

*1-7063-1*

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

*# Lot: 1-7063-1*

38.0

ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIÈCES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 22-5-09 Sceau:



*N.T.*

39.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

*# Lot: 1-22968-1*

40.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)

*# Lot: 1-23133-2*

41.0

PRIMER

APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Appliquer le primer selon I.G. 0008

*1x primer final  
26/05/09*

Date: 25/05/09 Sceau:



Date: Jeudi, 2009-04-23 08:40:50

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-2

Numéro Job: 43781

Numéro Article: DKC134-0067

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

42.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

27-05-09

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



43.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: 1

Date: 27-5-09

Sceau: \_\_\_\_\_



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E  
AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1  
REF CANADIAN STC: SH92-41  
REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

## ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

45407

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

## APPROVED

BY: D. SHEPHERD (DE # 02)  
DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8






A	NEW ISSUE	CP	09.05.26
DESIGN	<u>GP</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>GP</u>		
CHECKED	<u>GP</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>GP</u>	DSI 9463	SHEET 1 OF 5
APPROVED	<u>GP</u>	TITLE	SCALE
DE APPR.	<u>GP</u>	SIDE DOOR MODIFICATION	NTS
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**To install the DSI-9463-011 Door Latch Kit:**

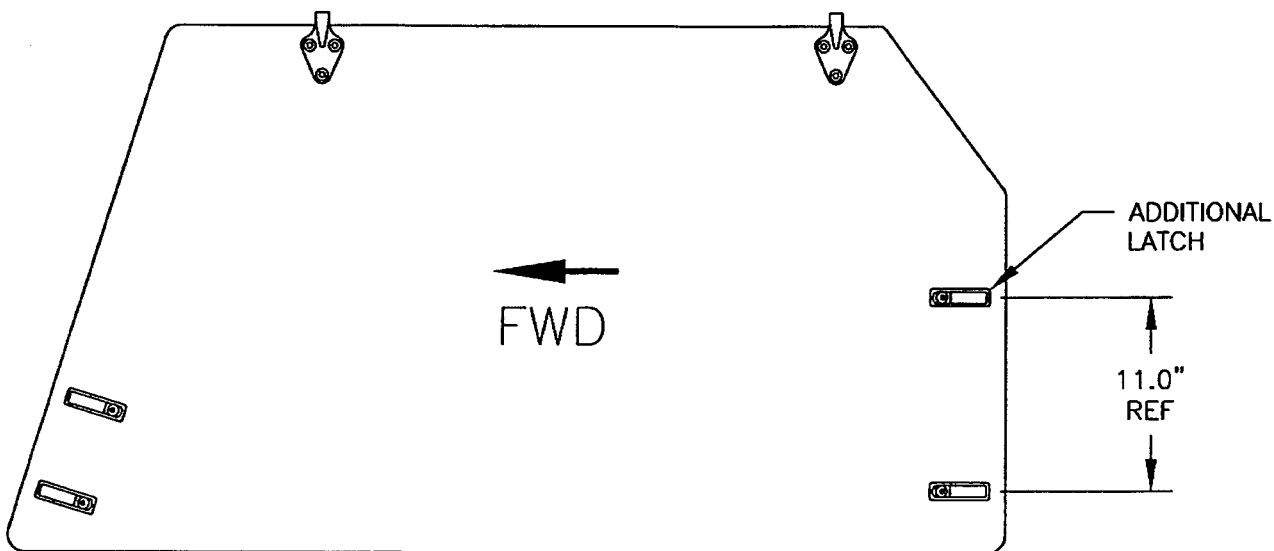
- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	09.05.26
CERT. NO.:	SH92-41
ISSUE NO.:	8

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		DSI 9463	SHEET 2 OF 5
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**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)  
D35X-589-042/-043 (SIMILAR)**

45407

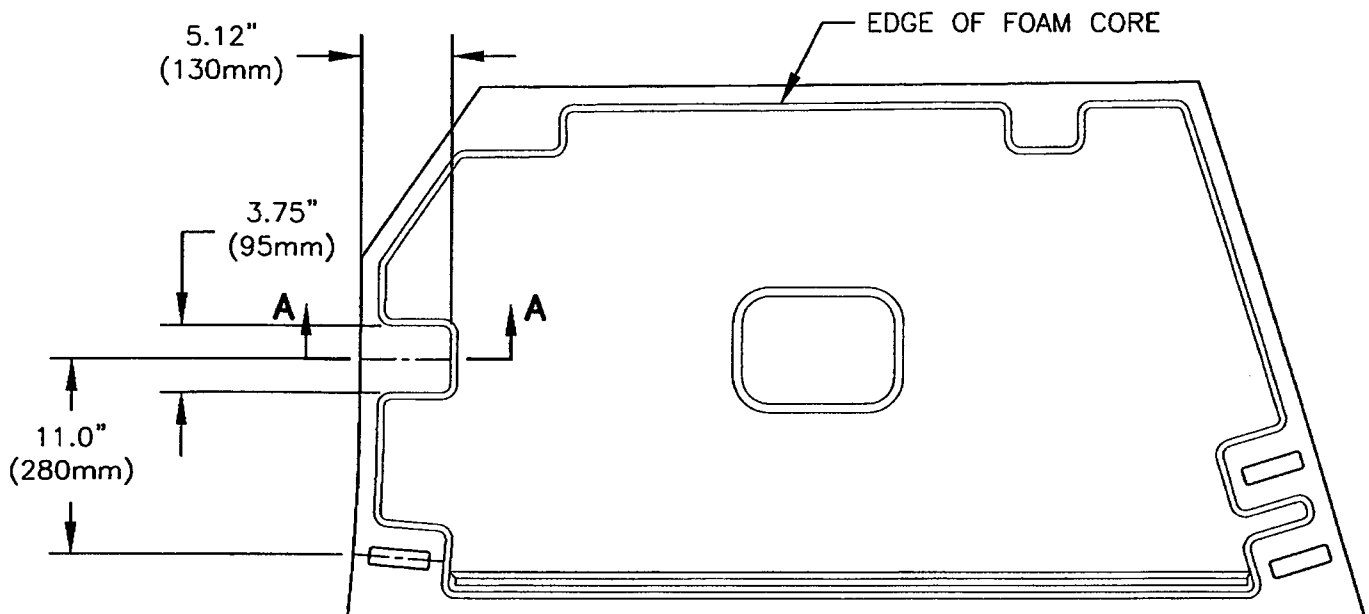
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BRANCH  
DAO # 01-O-01

**APPROVED**

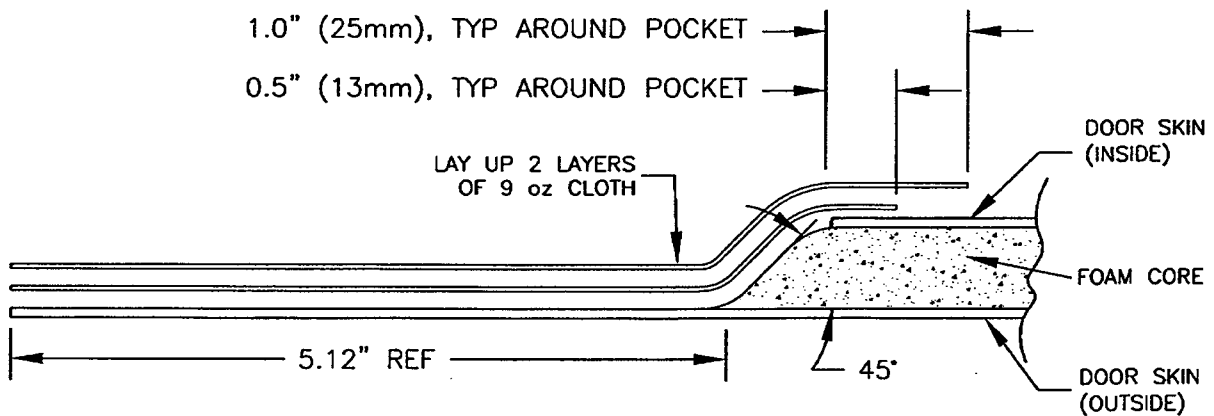
BY: [Signature]  
D. SHEPHERD (DE #02)

DATE: 09.05.26  
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ISSUE NO.: 8

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MFG. APPR.	<u>[Signature]</u>	DSI 9463	SHEET 3 OF 5
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**FIGURE 2: TRIMMING FOAM CORE  
(VIEW LOOKING AT INSIDE OF DOOR)  
(-041 SHOWN. -042/-043 SIMILAR)**



**SECTION A-A**

45407

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

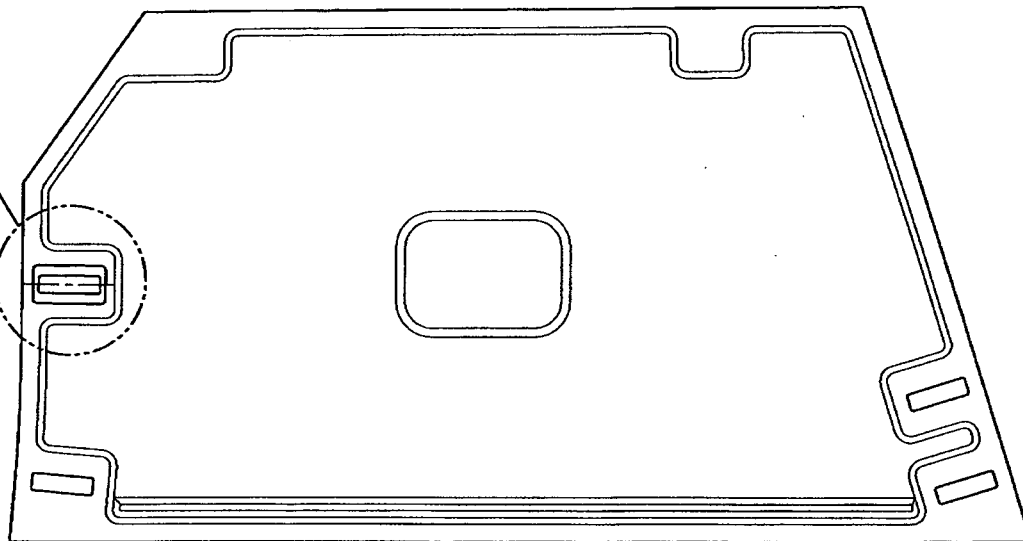
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
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SEE  
DETAIL B

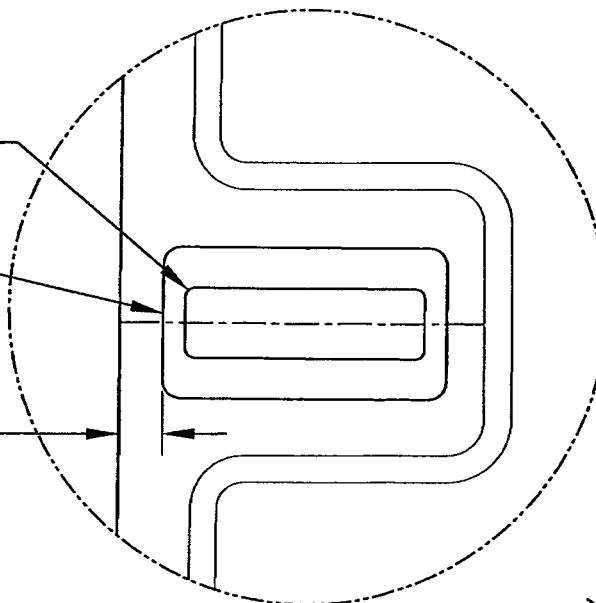


**FIGURE 3: CUTTING LATCH HOLE**

CUT HOLE THROUGH  
SKIN USING D2621 AS  
TEMPLATE

D2621 LATCH PLATE

0.60"  
(15.2mm)



**DETAIL B**







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CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

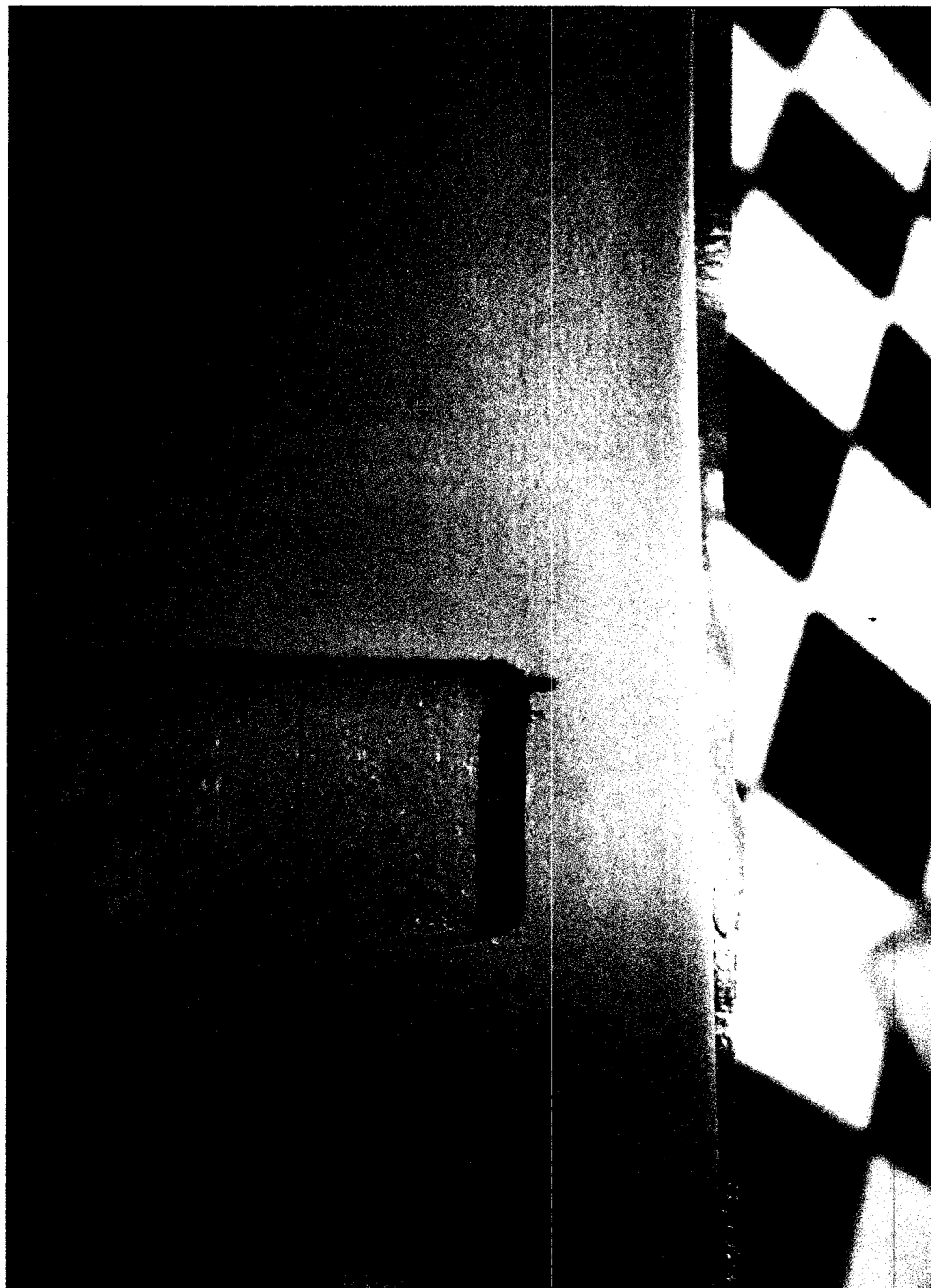
APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		DSI 9463	SHEET 5 OF 5
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## Chris Provencal

---

**From:** dshepherd@dartaero.com  
**Sent:** May 29, 2009 1:58 PM  
**To:** Dan Stow  
**Cc:** cprovencal@dartaero.com; Mike Petsche  
**Subject:** Re: Side Door NCR

Dan .... Sounds good.  
Chris ... Use this email to sign off the work order.

David

-----Original Message-----

From: Dan Stow  
To: 'David Shepherd'  
To: 'Chris Provencal'  
Cc: Mike Petsche  
Sent: May 29, 2009 11:28 AM  
Subject: RE: Side Door NCR

Ok Russ is going to Round out the cut and fill it with the fiberglass filler.

Thanks David,

Dan Stow  
Technical Support  
Dart Aerospace Ltd.  
dstow@dartaero.com  
Tel: 613.632.5200  
Cell:613.676.0992

-----Original Message-----

From: David Shepherd [mailto:dshepherd@dartaero.com]  
Sent: May 29, 2009 1:26 PM  
To: 'Dan Stow'; 'Chris Provencal'  
Cc: 'Mike Petsche'  
Subject: RE: Side Door NCR

Dan,

Chris didn't mention that. He mentioned bondo to me on the phone.  
I said no to the bondo.  
I am OK with the fiberglass filler, as long as it bonds to the existing laminate.  
I also suggested to Chris that we fill with milled fibers and resin.  
Can we smooth out the cut before we fill to prevent cracking in the future?

David

-----Original Message-----

From: Dan Stow [mailto:dstow@dartaero.com]  
Sent: Friday, May 29, 2009 11:22 AM  
To: 'Chris Provencal'; 'David Shepherd'  
Cc: 'Mike Petsche'  
Subject: RE: Side Door NCR

Actually it would be Polyester Fiberglass Filler

Dan Stow  
Technical Support  
Dart Aerospace Ltd.  
dstow@dartaero.com